

## A-452 Pattern Wax

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A-452 is a pattern wax that does not include a filler material. Therefore, the wax pattern surface is smooth and thin. Additionally, there is no mold cracking due to de-waxing because the viscosity of this wax in its liquid state is very low. This wax is suitable for the production of general investment casting products such as machine and automobile parts.

### Physical Properties (Representative Value)

Wax Type	Non-Filled Wax	
Color	Green	
Softening point	72C	
Congeaing Point	60C	
Needle Penetration	200g/5sec./25C	10
Viscosity	at 120C	20 mPa·s
	at 110C	26 mPa·s
	at 100C	32 mPa·s

### Contraction by Injection Test Piece (Representative Value)

Injection Test Parameter		
Injection Temperature		54C
Injection Pressure		30 kg/cm <sup>2</sup>
Injection time		20 sec.
Contraction	125mm	1.14%
	75mm	1.07%
Surface Sink		0.15 mm
Length of Wax Flow		177 mm

### Strength by 3 Points Bending Test (Representative Value)

Size of Test Bar	10×10×80mm
Span	60 mm
Maximum Load	49 N
Maximum Bending Stress at Maximum Load	4.5 Mpa
Maximum Bending Strain at Maximum Load	3.0 mm
Young's Modulus	312 Mpa

